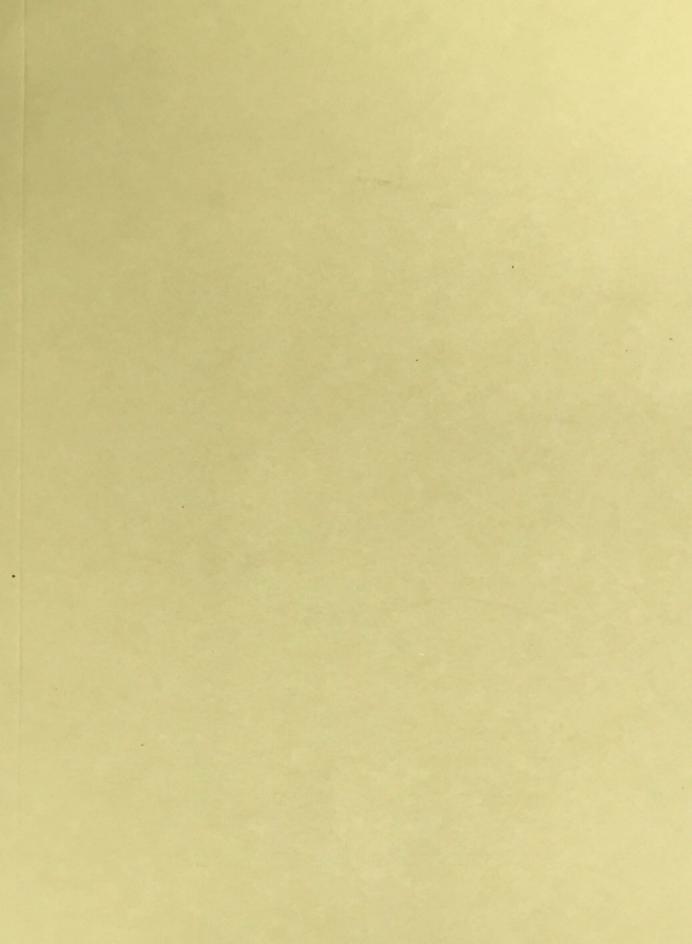
RG 104, 8NS-104-94-077 Box 6

8NS-104-94-077, Miscellaneous Correspondence & Memos, 1897-1994



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total 10 77 Jon Doc, 70 - 12-31-69 12-34 105 -24 70 -19 105-14 105-15 68 -12-1 colleng 69 -105-11 105-10 102 - 9 -3 scrap 105 - 8 68-5-2 scrap

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3-3-70 700 AM 24 rounds Bol 302 hote 416 to Finish 470 to Punch

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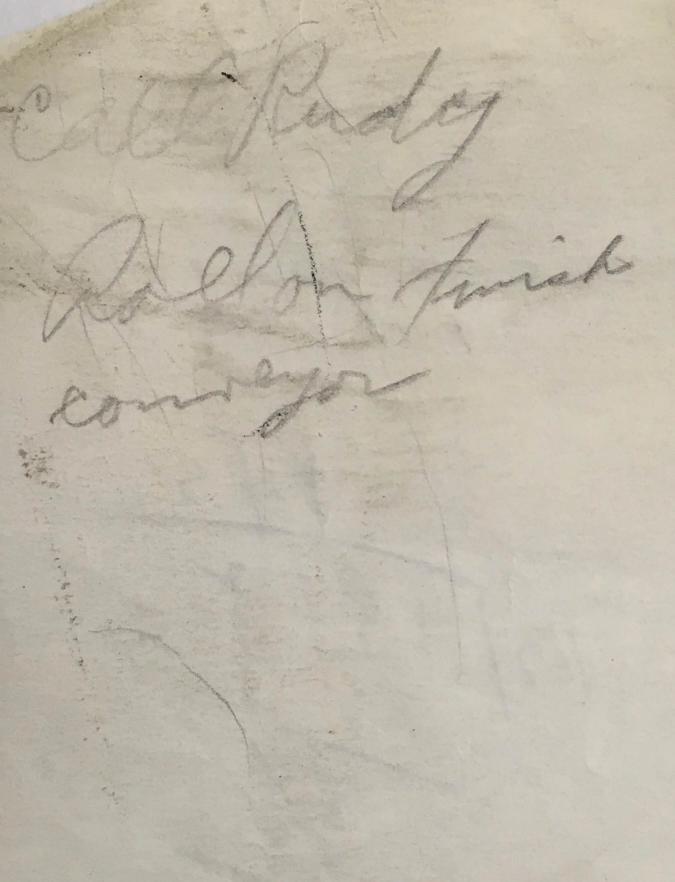
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Cut Bones Centr 9 Dinon 339,703 50 lentovon 390,978



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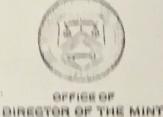
Standard Form 63 November 1961

Date		Time	
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MEMORANDU		Date	Time
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YOU WERE CA	ALLED BY-	YOU WERE VIS	ITED BY-
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REC @-215		•	Nix-Alloy
PASS	DIAL	GAUGE	X-RAY
/	.235	. 190.	
	1	ANNEAL.	
2	.185	./47	
3	.150	.114	
4	.130	.090	
5-	.118	.072 3E	leet - 115
6	.105	.060	093-1/4
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1.	235	.190	
	K	INNEAL.	**
2	220	./70	
3	190	./40	
4	160	.115	
5-	135	.090	
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THE DEPARTMENT OF THE TREASURY

WASHINGTON, D.C. 20220

June 25, 1970

RECEIVED

REGISTERED MAIL

JUN 29 1970

Mrs. Betty Higby
Superintendent
United States Mint
Denver, Colorado 80204

OFFICE OF SUPERINTENDENT U. S. MINT AT DENVER

Dear Mrs. Higby:

One Paso

Enclosed is a copy of a letter from the Covernment of Mexico requesting a cost estimate for the manufacture of cupro-nickel blanks.

You are requested to submit a cost estimate for the manufacture of 600 metric tons of cupro-nickel blanks having the following specifications:

Alloy

Copper 75% ± 1% Nickel 25% ± 1%

Diameter of cut blank Diameter of upset blank 29.0 MM - 29.2 MM 1.14/7-1.1496" 28.65 MM - 28.7 MM 1.1286"-1.1300"

Weight

9 Grams ± 0.2 Grams . 289 + Troy 02 138.89 grains = 27/797

Hardness

Rockwell B 1/16" max. 32

We are enclosing two (2) sample blanks provided by the Covernment of Mexico. When you have finished with these samples, please return them to this office by Registered Mail.

Sincerely,

For Mary Brooks

Director of the Mint

S.F. Carwile

Enclosures

Keep Freedom in Your Puture With U.S. Savings Bonds

MEXICO

ONE PESO BLANKS

INGOTS USED .	5,862
REJECTED AND SCRAPPED	260
DIAMETER OF BLANK	1.147 - 1.1496
THICKNESS OF BLANK	.060
WEIGHT	138.89 [±] 3 Gr.
PERCENT OF RECOVERY FROM INGOTS USED	59½
STARTING DATE	July 31, 1970
FINISHING DATE	January 6, 1971
LAST SHIPPING DATE	January 15, 1971
ROCK-WELL TEST	25
BOX MEASUREMENT (Inside)	21"X13½"X5½"
WEIGHT & NUMBER OF BAGS PER BOX	803.77 Oz., 4 Bags
TOTAL WEIGHT SHIPPED	19,290,480 OZ.
BALANCE OF BLANKS	1,617.54

First 17 trucks completed with the upset diameter 1.128 - 1.130.

Received telegram from Mexico for a smaller diameter. Size confirmed by telegram from Mexico. Truck number 18 had new size 1.122 - 1.125. Upset edge thickness .075. All trucks after truck 18 carried the new size.

UNITED STATES GOVERNMENT

Memorandum

Reling

TO

: Superintendents of Melting, Coining, Assay and

DATE: July 29, 1970

Mechanical Divisions

FROM : Cost Accounting Branch

SUBJECT: Job Numbers for Mexican Peso Blanks Order - 600 Metric Ton

Melting

Dept.	Charge		
7700	7751	Peso	Ingots

Process-Weighing

Rolling

Dept.	Charge		
7900 795	7951	Peso Rolling,	Slab Annealing,
		etc.	

Blanking

рерт.	Charge	1
8200	8251	Peso

Annealing and Cleaning

Upsetting

Selecting

Automatic-Weighing



MEMORANDUM (Continued)

Subject: Job Numbers for Mexican Peso Blanks Order - 600 Metic Ton

Counting

	Dept. 8700	Charge 8751	Peso Bagging, Boxing, and Weighing
Stores Items:		8751 8752 8753	Peso Bags Peso Boxes Banding Boxes for Shipping
Assay			
_	Dept. 3500	Charge 7751	Ingots
Mechanical			
	Dept. 6000	Charge 8251 8551	Changing and Sharpening Die Sets and Thimbles Adjustments for Segments and Discs
Material Handling:			
	<u>Dept.</u> 7700	Charge 7751	Ingots
	Dept. 8200	<u>Charge</u> 8251-4	Scrap
	Dept. 8700	Charge 8754	Preparation of Shipment

Mexico blanks - 50 centavos -Date started - Dec-5, 1969 Date finished - april 22, 1970 upret diameter - . 964 - . 967 wt per blank - 100.30 + - 3 gr. upret edge - . 076 - . 079 annealing - Rock-well test - 25-30 test. Total Ingots rised - 6,824 Total wt. of blanks shipped - 25,077,624 oz. melal - Cupro - ning Boy size - 4 bags to a box. 21" L- 1-D. x 1312" x 512" all inside measurement wt. To each bag. - 803.77 oz.

Commente: - Upset before annealing in order to get the upset edge thick enough. Blank size - .984-.985-.986-.987 Blank thickness - .059 ± .0015 I meyico Sample Blanks - One Pero Sample blanks indicate they were annealed after they were upset, also the ridge around edge is in place which shows metal did not move back which indicates blank was hard. Blank thickness - .060 no 1. blank - 1.125 - 1.129 no 2 blank 1.128 - 1.129

Upset edge thickness - .075 - .078

Upset shape - :047 flat edge with 45°

angles edges.

This shape is very similare to U.S. nickel upsetting tool.

wt-of one peso. . 289 troy oz.
138.89 gn. ± 27.791.
2.77 gn.

600 metre Tons 01-600 x 2,204.62 lbs.

Per-100 per. mexico 50s-High - 21.52 Low - 20.28 Standard - 20.90

,

50 - CENTAVO - MEXICO.

Rec. @,215		Nix-Alloy
PASS	Dinh	GAUGE X-RAY
1-		
1-	235	.190
		ANNEAL.
2		147
3	155	.114
4	135	.090
5-	125	.072 SELECT 115
6	110	.058 .093+1/2
EDGE +057	CENTER C	5 9 1 DIN: 984.25 Wt = 100/4 RIANS
	The state of the s	

Conts fut 3-2-thm3-4

3-2 870,185 3-3 957,029 3-4 1,257,722 3-5 1.484,988

3-6-1,384,070

25,077,624 17,035,624 oz 50 Barlavan 177,035,624 oz 50 Barlavan 25,035,624 oz 50 Barlavan

3712 2 An 800

april 7 mine 50 langue 4-1-78 V yscien 80 4-2-1200 4-3-114~ 4-6-1201 4-7-8- 181V 615 615

actual Recovery 36 75 ag " " 50 Cartavor Punched to Date Started 12-3-69 Completed 4-9-70 Total needed 25,077,624 og 3-7-70 17,035,624 og Cut thou 19,577,624 on meed 1, 4,700,000 og meed 1, 3-20-70 3-14 need 482 Ingota Ly To 3-34 need 3,478,000 m 3,208,000 m 2.808 432 m 935 Sugota 867 事子" 757 11 4-3 11 2,484 43203 670 2,206,926 og 1,741,879 og 1,407,134 og 1,075,831 og 6,84,853 6,22,254 4-9 11 595 4-ef " 470 - Duch 4-9 380 290 mead 188 ml 4.4 4-7 4-8 62,599 greeded Proched 152,643 glan 90044 og 4-9 4-9 68 2.4. Ingote for mepico 66 Inget serge 6,899 mogete total from mfB Cubans Centard

1-Centure
El. Salawador
Wt= 38.52-Sefrer

.055 5t.

El Salavador

5- Centaro

wt= 77.16

Alia - .900

300= 054

10 - Centaus

El Salavador.

057-1/2 g- lite

05-9-29- Huy

